Page 1

Insp.

Stamp

July 23, 2009 9:56:42 AM Item ID: D2229 Accept Setup Start В **Revision ID:** Stop Item Name: Doubler **Start Qty:** 60.00 **Start Date:** 27/07/2009 **Cust Item ID: Required Date: 31/07/2009** Req'd Qty: 60.00 **Customer:** Reference: Start Date: 09-67-23_{Tooling}: **Process Plan: Approvals:** Date: Stop QC: Date: ____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Reject Draw Plan Reject Draw Accept Work Center ID Description Qty Qty Number Rev. Code Number **Run Hours** Draw Nbr **Revision Nbr** D2229 Rev B 100 0.00 FLOW WATER JET Waterjet 0.00 Memo FLOW CNC Waterjet Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 QC 0.00 Memo Quality Control

120

QC

QC8- Inspect parts - second check

Memo

Quality Control

0.00

W/O:		WORK ORDER C	HANGES								
DATE	STEP PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
				•							
		·									
<u> </u>											

Part No: D2229

PAR #: NA Fault Category: Son Falo NCR (Yes) No DQA: A Date: 99-08.24

Date: 09.06.27

Disposition: Use as as QA: N/C Closed: Resolution: <u>accurated</u>

WORK ORDER NON-CONFORMANCE (NCR) NCR:50875 **Corrective Action** Section B **Description of NC** Verification **Approval Approval** DATE **STEP** Sign & Initial **Action Description** Section C Chief Eng QC Inspector Section A Date Chief Eng Chief Eng Qty(39) DUBIERS HAVE ENLARGED HOLES => \$0.325 P.(. works Set Poplens Acceptable. Dies NUT AFFECT STRENGTH OF DOUISEER m 69.08 21 100 19.02.4 09 0821 05/042

July 23, 2009 9:56:43 AM

Page 2

Item ID:

D2229

Accept

Revision ID: Item Name:

Start Date:

В

Doubler

QC:

27/07/2009

Start Qty: 60.00 Req'd Qty: 60.00

Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Required Date: 31/07/2009

Tooling:

Date:

Start

Stop

Stop

Setup Start



Process Plan:

Date:

Date:

SPC (Y/N):

Set Up/

Date:

Reject Qty

Run

Reject Insp.

Run Hours

Draw Rev.

Plan Code Accept Qty

Number

Stamp

130

Small Fab

Sequence ID/

Work Center ID

Small Fab

Small Fab

Operation

Description

Memo

Deburr. No sharp edges

0.00

0.00

08

140

HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Hand Finishing

150

QC3- Inspect Part Finish

=) 507/02/21

QC

Quality Control

Memo

Memo

0.00

Dart	Aeros	pace	Ltd
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W/O:		WORK ORDER CH	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE		By Date		Approval Chief Eng / Prod Mgr	Approval QC Inspector				
			,								

Part No: _		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:			WORK ORD	ER NON-CONFORMANO	E (NCR)			
		Description of NC		Verification	Approval	Annroyal		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
							[
	<u> </u>							
				, , , , , , , , , , , , , , , , , , ,				

Work Order ID 50875

July 23, 2009 9:56:43 AM

Page 3

Item ID:

Accept

Setup Start

Stop



Item Name: Doubler

Start Qty: 60.00

Cust Item ID:

Customer:

Draw

Reference:

Approvals:

Process Plan:

QC:

Date:

Start



Date:

Rev.

Stop

Sequence ID/ **Work Center ID**

160

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

QC21- Final Inspection - Work Order Release

Memo

Run Hours

0.00

0.00

Number

Reject Qty

Reject Number Stamp

170

Quality Control

Memo

0.00

0.00

TST /650821 MF 09.08-21

D2229

27/07/2009

Required Date: 31/07/2009

Revision ID: В

Start Date:

Req'd Qty: 60.00

Date:

Date:

Tooling:

SPC (Y/N):

Set Up/

Draw

Plan Code Accept Qty



Dali Aelusuace Lii	art Aerosp	ace l	_td
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W/O:		WORK ORDER CHANGES	3				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
-							·
Part No	:	PAR #: Fault Category:	NCR: Ye	s No DQ	A:	Date: _	

Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: ____

		WORK ORDI	ER NON-CONFORMANO	CE (NCR)			
	Description of NC		Corrective Action Section B		Varification	Approval	Approval QC Inspector
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	
	STEP	STEP Description of NC Section A	STEP Description of NC Section A Initial Chief Eng	STEP Description of NC Section A Chief Eng Corrective Action Section B Initial Action Description Chief Eng Chief Eng	STEP Description of NC Section A Initial Chief Eng Chi	STEP Description of NC Section A Initial Chief Eng Chi	STEP Description of NC Section A Initial Chief Eng Chi

^{*}H;\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

July 23, 2009 9:56:42 AM

Work Order ID: 50875

Parent Item:

D2229RevB

Parent Item Name: Doubler

Comments:



19059

Start Date: 27/07/2009

Required Date: 31/07/2009

Start Qty: 60.00

Required Qty: 60.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No		×	100	sf	150.7360	3.2905			



2024-T3 .063 sheet

Warehouse	Loc Oty	Loc Code	
Location			
Main Warehouse			
MAT	150.7360005		
102942	1.5		
105916	3.69		
106223	1.47		
109463	24.2		_
110980	15.45		
111787	102.426001		1

2

Dart Aerospace Ltd

W/O:		WORK ORDER CH	IANGES				
DATE	STEP	STEP PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					i		
Part No	<u> </u>	PAR #: Fault Category:	NCR: Yes	No DQ) A :	Date:]

 Resolution: ________ Disposition: ________ QA: N/C Closed: _______ Date: _______

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
DATE		Description of NC		Corrective Action Section B	Verification	Ammunus	A				
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
					·						
				•							
NOTE: D	ate & initial a	Il entries				<u> </u>		1			

DART AEROSPACE LTD	Work Order:	50875
Description: Doubler	Part Number:	D2229
Inspection Dwg: D2229 Rev: B		Page 1 of 1

	F	T ARTICLE II		_			
		First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	1 6.0	mments
2.50	+/-0.030	2.495	V		Vern		· · · · ·
1.810	+/-0.010	1.804	/		Vern		
0.690	+/-0.010	0.683			vers		
3.00	+/-0.030	2.993			vern		·
2.343	+/-0.010	2,342	V		VERNI		**
0.656	+/-0.010	0.653	ĩ/		Vers		
Ø0.3125	+0.006/-0.001	0.316	/		Vern Vern Vern		
easured by:	M M	Audited by:			Prototype A	Approval:	N/A
Date:	09 08 21	Date:	ज्ये व्या			Date:	N/A
ev Date A 07.09.06	Change New Issue		of often			Revised by	

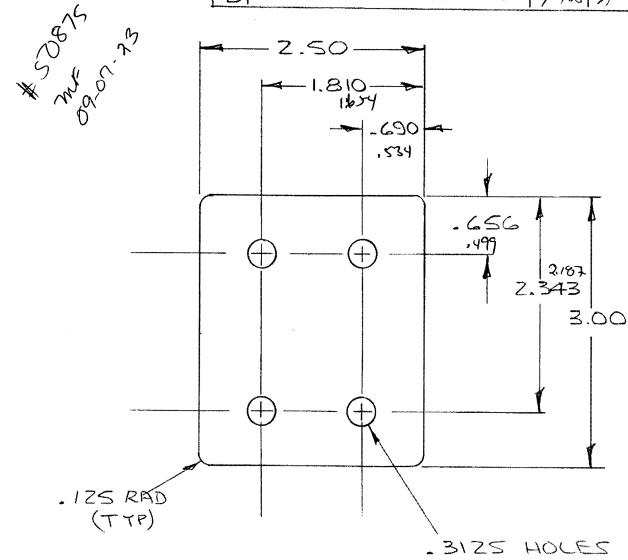
Dart Aerospace Ltd

										
W/O:			WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		`								
					. :					
			-							,
Part No: PAR #:			Fault Category:			_ NCR: Yes No DQA: Date:				
	R	esolution:	Disposition	n:	QA: I	WC Clos	sed:		Date:	
NCR:			WORK ORDI	ER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC Section A		tion B	Verifica			on Approval	Approval	
DAIL	OTE		Initial Ac Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector
							į			
										1



DRAWN
BRADLEY 34-3.28
DESIGN
BRADLEY 94.3.28
DRAWING NO.
BRADLEY 94.3.28
DITTLE
DOL BLER

A NEW ISSUE 94/3/16 9 B ALODINE WAS ANODIZE 77/11/06 9



MATERIAL:

2014-T3 ALUMINUM

. 063 THICK

FINISH:

ALODINE PER OSI 005-4.1

1.156

4 PLACES

Dart Aerospace Ltd

W/O:	<u>-</u>		WC	ORK ORDER CHA	ANGES					;
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
- 9		a								
						:				
Part No:		PAR #:	Fault Cate	gory:	NCF	R: Yes I	Yes No DQA:		Date:	
Resolution:			Disposition:			QA: N/C Closed: Date:				
NCR:		•	WORK ORD	ER NON-CONFO	RMANCE	(NCR)			
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descript		Section B tion	Sign &	Verification Section C		Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng		Date				
				- 80.9 (80.9)						